

538



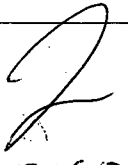

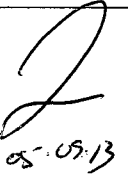
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24130
<b>Description:</b> Dart 13-Man Shoulder Harness Kit (205/212/214/412)		<b>Part Number:</b>	D3196-3 <del>D412-702-011</del>
4.02.23 <del>4.02.23</del>			
<b>Dwg:</b> D3195 Rev. A; D3196 Rev. A; D3197 Rev. A		<b>Qty:</b>	15 Kit(s)
<b>Ref:</b> D412-702 Rev.A page 9			Page 1 of 4


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Note:</b> D412-702-011 Kit consists of (2) D3195-041; (2) D3195-043; (1) D3196-1; (1) D3196-3; (1) D3196-4; (2) D3197-041.	W	05/03/15	15
2	DC	Photocopy bluefile and create labels per PPP D412-702-011 CHG001			
3	MV	<del>Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (0.75" x 2.00") x 3.60" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B0.750x02.000) Identify for D3195-1 Batch:</del>			
4	MV	<del>Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (1.50" x 1.25") x 3.60" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B1.500x01.250) Identify for D3195-3 Batch:</del>	N/A		
5	MV	<del>Cut blank: (0.75" x 1.50") x 26.200" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) Identify for D3196-1 Batch:</del>			
6	MV	<del>Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (0.75" x 1.50") x 34.750" long Bar Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) (M6061T6B0.750x01.500) Identify (1) for D3196-3 ~ Identify (1) for D3196-4 Batch: M 15031 M18453</del>	E	05/02/09	15
7	MV	<del>Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: 29.125" long Round Bar Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD (M7075T73R1.000) Identify for D3197-1 Batch:</del>			
8	MV	<del>Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-1</del>			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr and Tumble			
11	QC8	Second check			
12	MV	<del>Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3</del>	N/A		
13	QC2	Inspect parts as they come off the CNC machine			
14	MV	Deburr and Tumble			
15	QC8	Second check			

RELEASE

04.01.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/04/09	#20	CLIMK TOO DEEP BY $\approx 0.050"$ ON 1X D3196-3	 05.09.09	ACCEPTABLE DEVIATION	 05.09.09	 05-09-13	 05.09.09	 05-09-13

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/10/26

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 24130
<b>Description:</b> Dart 13-Man Shoulder Harness Kit (205/212/214/412)		<b>Part Number:</b> <del>D3196-3</del> D412-702-011
Dwg: D3195 Rev. A; D3196 Rev. A; D3197 Rev. A Ref: D412-702 Rev. A page 9		<b>Qty:</b> 15 Kit(s) Page 2 of 4

Step	Location	Procedure	By	Date	Qty
16	MV	Machine D3196-1 as per Folio FA339 and Dwg D3196 <b>Identify as D3196-1</b>			
17	QC2	Inspect parts as they come off the CNC machine			
18	MV	Deburr	N/A		
19	QC8	Second check			
20	MV	Machine D3196-3 as per Folio FA339 and Dwg D3196 <b>Identify as D3196-3</b>	SD	05.09.10	15
21	QC2	Inspect parts as they come off the CNC machine	SD	05.09.10	15
22	MV	Deburr	SD	05.09.10	15
23	QC8	Second check	SD	05.09.10	15
24	MV	Machine D3196-4 as per Folio FA339 and Dwg D3196 <b>Identify as D3196-4</b>	SD	05.09.10	15
25	QC2	Inspect parts as they come off the CNC machine			
26	MV	Deburr			
27	QC8	Second check			
28	MV	Machine D3197-1 as per Folio FA340 and Dwg D3197 <b>Note: Need to be faced to size</b> <b>Identify as D3197-1</b>	N/A		
29	QC2	Inspect parts as they come off the CNC machine			
30	MV	Deburr			
31	QC8	Second check			
32	FP	Chemical Conversion Coat as per QSI 005.4.1 D3195-1/-3; D3196-1/-3/-4; D3197-1	FC	050920	15
33	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005.4.3 D3195-1/-3; D3196-1/-3/-4; D3197-1	FC	050921	15
34	QC3	Inspect work to Step 33.	ML	05.09.21	15
35	GA	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (4.986" x 0.500") x 0.125" thick as per Dwg D3195 Material: D3195 Rubber 2.500" Punch holes as per Dwg <b>Identify as D3195-5</b> Batch: _____	N/A		
36	GA	Cut (2) blanks per (1) D412-702-011 Kit Cut blanks: (4.986" x 1.000") x 0.125" thick as per Dwg D3195 Material: D3195 Rubber 2.500" Punch holes as per Dwg <b>Identify as D3195-7</b> Batch: _____			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24130
<b>Description:</b> Dart 13-Man Shoulder Harness Kit (205/212/214/412)		<b>Part Number:</b>	D3196-3
04.02.23 H			
<b>Dwg:</b> D3195 Rev. A; D3196 Rev. A; D3197 Rev. A1		<b>Qty:</b>	15 Kit(s)
<b>Ref:</b> D412-702 Rev.A page 9			Page 3 of 4

Step	Location	Procedure	By	Date	Qty																																																																				
37	GA	Bond D3195-5 into D3195-1 as per Dwg D3195 <b>Pick:</b> <table border="0"> <tr> <td><u>Qty</u></td> <td></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>A/R</td> <td></td> <td>Contact Cement</td> <td></td> </tr> </table> <b>Identify as D3195-041</b>	<u>Qty</u>		<u>Description</u>	<u>Batch</u>	A/R		Contact Cement																																																																
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A/R		Contact Cement																																																																							
38	GA	Bond D3195-7 into D3195-3 as per Dwg D3195 <b>Pick:</b> <table border="0"> <tr> <td><u>Qty</u></td> <td></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>A/R</td> <td></td> <td>Contact Cement</td> <td></td> </tr> </table> <b>Identify as D3195-043</b>	<u>Qty</u>		<u>Description</u>	<u>Batch</u>	A/R		Contact Cement																																																																
<u>Qty</u>		<u>Description</u>	<u>Batch</u>																																																																						
A/R		Contact Cement																																																																							
39	QC5	Inspect work to Step 38																																																																							
40	GA	Assemble (2) D3197-041 as per Dwg D3197. (Note: D3197-1 is on BOM as material from Step 7) <b>Pick:</b> <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Part Number</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>4</td> <td>D2690-5</td> <td>Lanyard</td> <td></td> </tr> <tr> <td>2</td> <td>D3197-1</td> <td>Bar</td> <td></td> </tr> <tr> <td>4</td> <td>D3242-1</td> <td>Tag</td> <td></td> </tr> <tr> <td>12</td> <td>AN960JD10</td> <td>Washer</td> <td></td> </tr> <tr> <td>4</td> <td>DARS-004</td> <td>Pin Pin</td> <td></td> </tr> <tr> <td>4</td> <td>MS21042L3</td> <td>Nut (or -3)</td> <td></td> </tr> <tr> <td>4</td> <td>MS27039-1-24</td> <td>Bolt</td> <td></td> </tr> </table> <b>Identify as D3197-041</b>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	4	D2690-5	Lanyard		2	D3197-1	Bar		4	D3242-1	Tag		12	AN960JD10	Washer		4	DARS-004	Pin Pin		4	MS21042L3	Nut (or -3)		4	MS27039-1-24	Bolt																																								
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4	MS21042L3	Nut (or -3)																																																																							
4	MS27039-1-24	Bolt																																																																							
41	QC5	Inspect work to Step 40																																																																							
42	KP	<b>Pick: Packing Kit (Note: D3195-041/-043, D3196-1/-3/-4 are on BOM as material from Steps 3-6, 35-36)</b> <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Part Number</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>2</td> <td>D3195-041</td> <td>Bracket</td> <td></td> </tr> <tr> <td>2</td> <td>D3195-043</td> <td>Bracket</td> <td></td> </tr> <tr> <td>1</td> <td>D3196-1</td> <td>Bar</td> <td></td> </tr> <tr> <td>1</td> <td>D3196-3</td> <td>Bar</td> <td></td> </tr> <tr> <td>1</td> <td>D3196-4</td> <td>Bar</td> <td></td> </tr> <tr> <td>2</td> <td>D3197-041</td> <td>Bar</td> <td></td> </tr> <tr> <td>4</td> <td>D3198-1</td> <td>Fitting</td> <td></td> </tr> <tr> <td>18</td> <td>D3215-041</td> <td>Harness Assembly</td> <td></td> </tr> <tr> <td>4</td> <td>D3215-043</td> <td>Harness Assembly</td> <td></td> </tr> <tr> <td>4</td> <td>AN4-5A</td> <td>Bolt</td> <td></td> </tr> <tr> <td>4</td> <td>AN4-13A</td> <td>Bolt</td> <td></td> </tr> <tr> <td>8</td> <td>AN4-20A</td> <td>Bolt</td> <td></td> </tr> <tr> <td>20</td> <td>AN960JD416</td> <td>Washer</td> <td></td> </tr> <tr> <td>12</td> <td>MS21042L4</td> <td>Nut (or -4)</td> <td></td> </tr> <tr> <td>8</td> <td>MS24694-S152</td> <td>Screw</td> <td></td> </tr> <tr> <td>2</td> <td>D3268-1</td> <td>Placard</td> <td></td> </tr> </table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	2	D3195-041	Bracket		2	D3195-043	Bracket		1	D3196-1	Bar		1	D3196-3	Bar		1	D3196-4	Bar		2	D3197-041	Bar		4	D3198-1	Fitting		18	D3215-041	Harness Assembly		4	D3215-043	Harness Assembly		4	AN4-5A	Bolt		4	AN4-13A	Bolt		8	AN4-20A	Bolt		20	AN960JD416	Washer		12	MS21042L4	Nut (or -4)		8	MS24694-S152	Screw		2	D3268-1	Placard				
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																																																																						
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1	D3196-4	Bar																																																																							
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8	MS24694-S152	Screw																																																																							
2	D3268-1	Placard																																																																							
43	QC4	Inspect Kit 100% for Completeness on the W/O																																																																							
44	PK	Identify and pack for shipping as per PPP D412-702-011 ID to stack D3196-3																																																																							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24130
<b>Description:</b> Dart 13-Man Shoulder Harness Kit (205/212/214/412)		<b>Part Number:</b>	D3196-3 D412-702-011
04.02.23			
<b>Dwg:</b> D3195 Rev. A; D3196 Rev. A; D3197 Rev. A		<b>Qty:</b>	15 Kit(s)
<b>Ref:</b> D412-702 Rev.A page 9			Page 4 of 4

Step	Location	Procedure	By	Date	Qty
45	AC	Cost / part 37.83	Suz	05.10.26	15
46	DC	Close W/O 35.48 Inspect Level 21	PD	05/10/26	15

Rev	Date	Change	Revised By	Approved
A	03.10.17	New issue	KJ/RF	

**RELEASED**  
04.01.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	24130
Description: Bar		Part Number:	D3196-3
Inspection Dwg: D3196	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

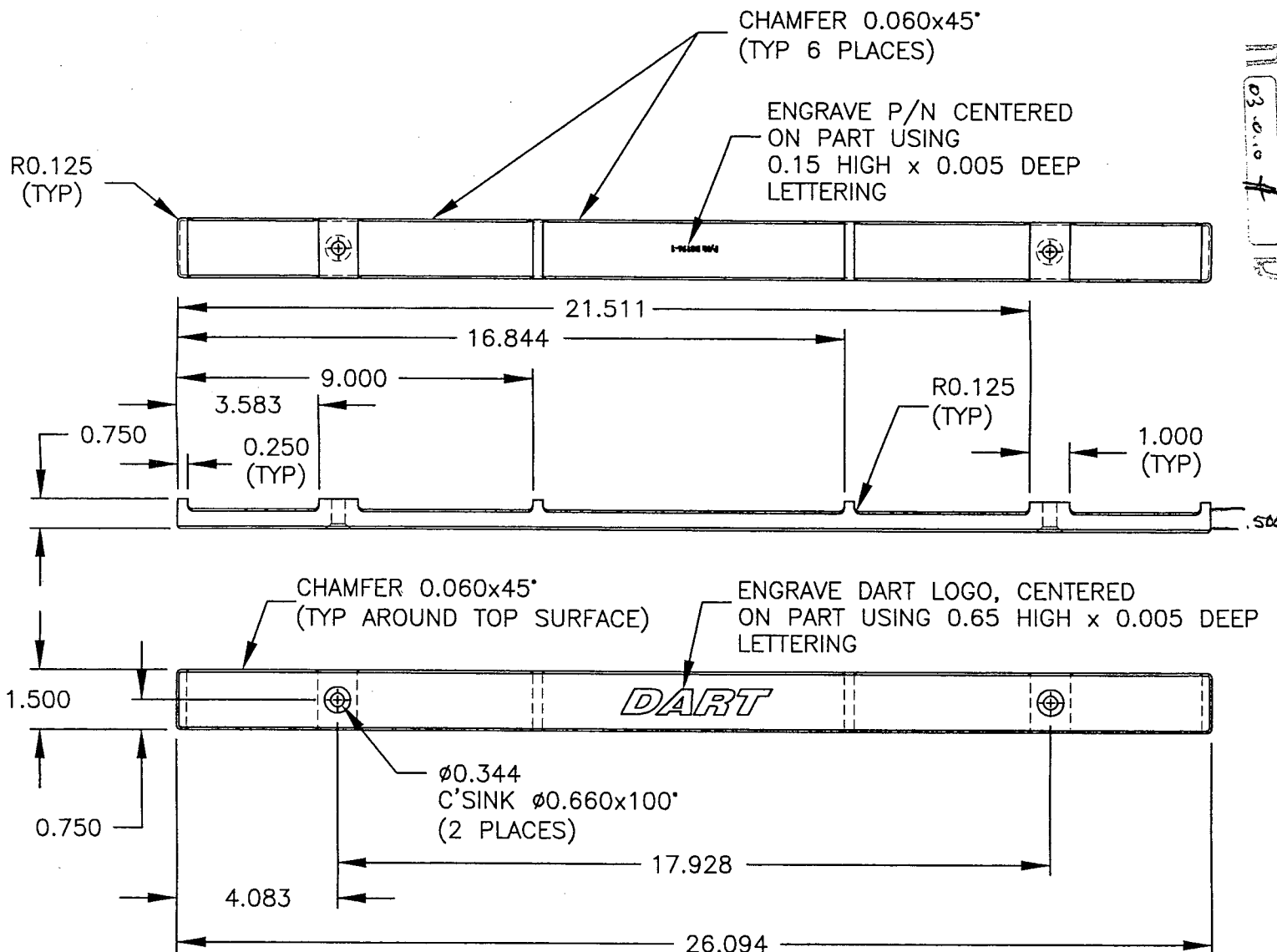
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	✓		Tape measure.	
33.650	+/-0.005	33.647	✓			
0.488	+/-0.005	0.491	✓			
17.011	+/-0.010	17.011	✓		Tape measure.	
0.512	+/-0.005	0.508	✓			
1.500	+/-0.010	1.498	✓		mat. thickness.	
0.464	+/-0.010	0.460	✓			
0.504	+/-0.010	0.500	✓			
Ø0.344	+0.005/-0.000	0.344	✓			
Ø0.660 x 100°	+/-0.005	0.664 x 100°	✓			
0.962	+/-0.005	0.965	✓			
0.750	+/-0.010	0.748	✓		mat. thickness.	
4.750	+/-0.010	4.751	✓			
12.531	+/-0.010	12.530	✓		Tape	
16.999	+/-0.010	17.000	✓		Tape	
21.844	+/-0.010	21.894	✓		Tape	
29.625	+/-0.010	29.625	✓			
0.250	+/-0.010	0.246	✓			
1.000	+/-0.010	0.998	✓			
R0.125	+/-0.010	0.125	✓		R, S, T	
0.987	+/-0.010	0.988	✓			
0.060 x 45°	+/-0.010	0.060 x 45°	✓			

Measured by: <i>ES</i>	Audited by: <i>me</i>	Prototype Approval:	N/A
Date: 05/09/09	Date: 05/09/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011)	KJ/RF	<i>RF</i>

RELEASED

*RF* 04.04.20



RELEASED  
03.06.25

**DART**

QA ISSUED

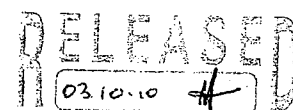
DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	CP	D3196
DATE	TITLE	SHEET 1 OF 3
03.06.25	BAR	SCALE
A	03.06.25	NEW ISSUE
		1:4

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 24130





**D3196-1 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



# DART



DESIGN		DAR1 AEROSPACE LIB	
DESIGNED BY		HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED	
		DRAWING NO.	REV. A
		D3196	SHEET 2 OF 3
DATE		TITLE	SCALE
03.06.25		BAR	1:5

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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# RETURN TO ENGINEERING

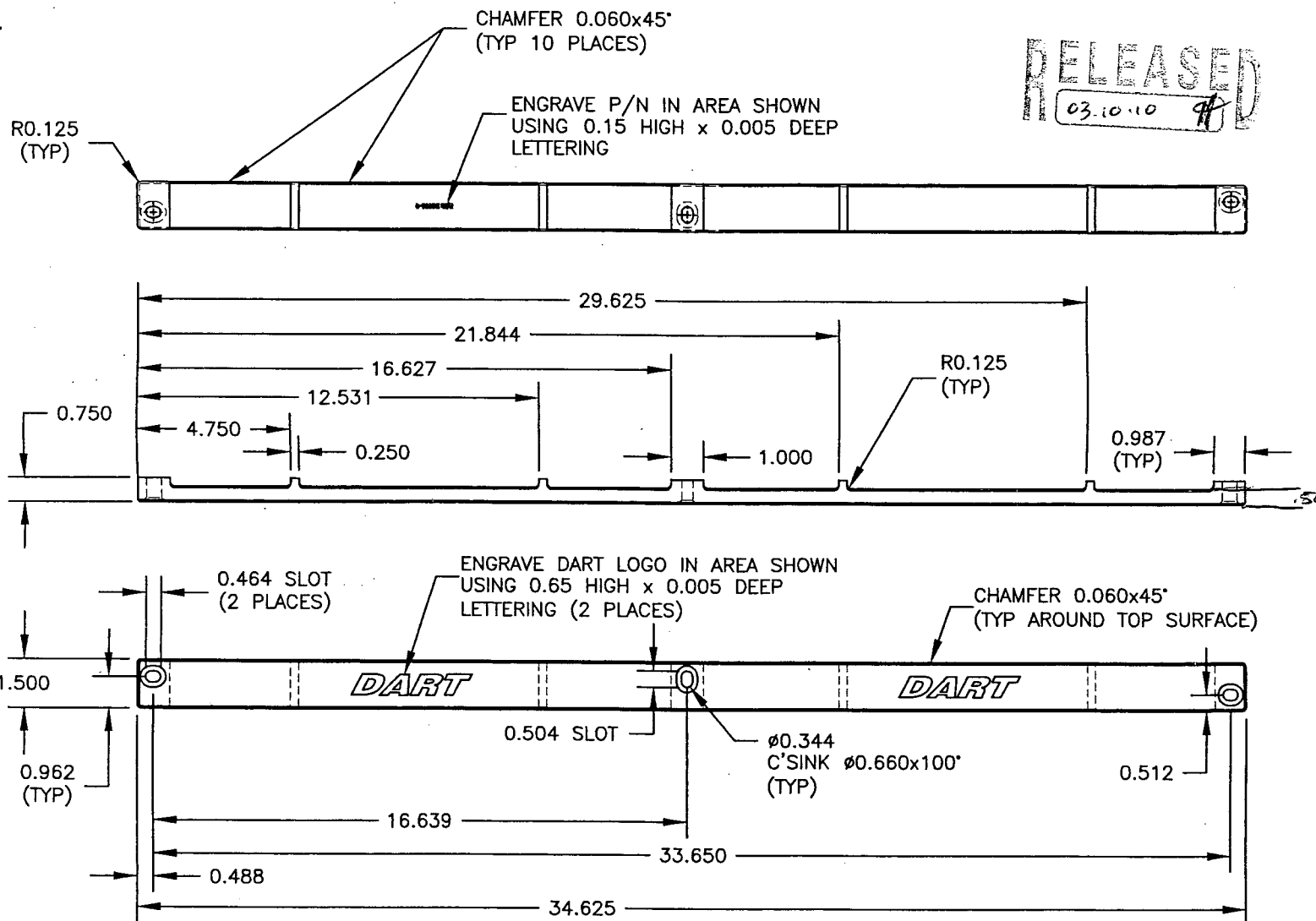
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# WORK ORDER

NO. 24130

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#### D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 24130

DESIGN	W	DRAWN BY	W	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	03.06.25	DRAWING NO.	D3196	REV. A
TITLE	BAR	SHEET	3 OF 3	SCALE
				1:5

**DART**

QA COPY ISSUED

RELEASED  
03.10.10

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 30, 2005  
07:42 am

Work Order No : 0024130  
Project Name : D3196-3  
Project For : WK538  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3196-3  
Description : Bar  
Manufactured : Yes  
Amount Req'd : 15  
Amount Done : 0  
Start Date : 08-29-05  
Est Finish Date : 09-21-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00